

Date:
User:Wednesday, 14/01/2009 9:01:27 AM
Melanie Fauteux

Process Sheet

NOT P.

Add D-S.

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LARGE BUBBLE WINDOW KIT, LH
 Job Number : 44748
 Estimate Number : 13717
 P.O. Number :
 This Issue : 14/01/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : // Type : SMALL /MED FAB
 Previous Run :
 Written By :
 Checked & Approved By : MF 09-01-13
 Comment : Est Rev:A 09-01-13 rev.C as per dwg DD verified by:EC

Part Number : D412761045
 Drawing Number : PRELIM
 Project Number : N/A
 Drawing Revision : PRELIM
 Material :
 Due Date : 19/01/2009 Qty: 1 Um: Each

POSITIVE RECALL

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D412-761-045 CHG001



2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit



3.0 D36761 BUBBLE WINDOW



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

BUBBLE WINDOW

batch: 4144 Daryl

4.0 D36781 Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Placard

batch: 46354 Eng send 18hr

sent later mr 09-01-16



5.0 D37001 Inboard Window Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Inboard Window Doubler

batch: B445995.1 ~~DT9458~~ DT9458 09.06.08 Eng send 18hr.

Qty: 1

cutting template Batch: NA

B/S 09/01/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☐ DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 14/01/2009 9:01:27 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LARGE BUBBLE WINDOW KIT, LH

Job Number: 44748

Part Number: D412761045

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	D37003	Outboard Window Doubler
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Outboard Window Doubler

batch: 44600

1 SS 09/01/16 (X)

7.0	D37011	Floor Doubler
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Floor Doubler

batch: B05061

1 SS 09/01/16 (X)

8.0	D37021	Fwd Doubler
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Fwd Doubler

batch: B44598

1 SS 09/01/16 (X)

9.0	D37031	Aft Doubler
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Aft Doubler

batch: B05062

1 SS 09/01/16 (X)

10.0	D37033	Aft Corner Doubler
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Aft Corner Doubler

batch: B44596

1 SS 09/01/16 (X)

11.0	D37035	Aft Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Aft Cap

batch: B44597

1 SS 09/01/16 (X)

12.0	D37041	ESCUTCHEON
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

ESCUTCHEON

batch: 44761

1 SS 09/01/16 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 14/01/2009 9:01:27 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LARGE BUBBLE WINDOW KIT, LH

Job Number: 44748

Part Number: D412761045

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	D37081	Angle
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Angle

batch: B05063

1/SS 09/01/16 EC

14.0	D37083	Angle
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Angle

batch: B05064

1/SS 09/01/16 (X)

15.0	D37091	Angle
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Angle

batch: B05065

1/SS 09/01/16 (X)

16.0	D37093	Angle
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Angle

batch: B05066

1/SS 09/01/16 (X)

17.0	D38021	Window Seal
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Window Seal

Cut seal 135.00" long batch: 44630

1/SS 09/01/16 EC

18.0	AN37A	Bolt
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Comment: Qty.: 26.0000 Each(s)/Unit Total : 26.0000 Each(s)

Bolt

batch: M5288 X12

-14 1/SS 09/01/16 (X)

19.0	AN960JD10	Washer
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Comment: Qty.: 52.0000 Each(s)/Unit Total : 52.0000 Each(s)

Washer

batch: M69001

1/SS 09/01/16 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 14/01/2009 9:01:27 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LARGE BUBBLE WINDOW KIT, LH

Job Number: 44748

Part Number: D412761045

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

MS21042L3

Nut



Comment: Qty.: 26.0000 Each(s)/Unit Total : 26.0000 Each(s)

Nut

batch:

M108816

1/88 09/01/16

21.0

MS24694C5

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Screw

batch:

M106015

1/88 09/01/16 (X)

22.0

MS24694C13

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Screw

batch:

M108508

1/88 09/01/16 (X)

23.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

ENGINEERING
APPROVAL

09.01.16

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-761-045

Location:

PPP Rev:

transfer
Dart (21guy)

~~DON'T KNOW WHERE IT IS~~

25.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECTIVE 09.01.16 AUTH 4

RELEASED _____ DATE _____

u 09.01.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 14/01/2009 3:14:03 PM
User: Linda Lacelle

Process Sheet

DUPLICATE

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 41414
Estimate Number : 13138
P.O. Number :
This Issue : 14/01/2009 S.O. No. :
Prsht Rev. : NC
First Issue : 19/08/2008 Type : THERMOFORMING
Previous Run : 41413

Drawing Name : BUBBLE DOOR 412 VERTICLE REFERENCE

Part Number : D36761
Drawing Number : D3676
Project Number : 00224
Drawing Revision : B Preliminary
Material :
Due Date : 26/08/2008

Qty: 3 Um: Each

Written By :
Checked & Approved By : mf 09-01-14
Comment : Est. Rev A New Product 01/24/2008 DL Verified:JLM

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MACRLICS250 5236 Plexiglass G .250



Comment: Qty.: 13.0000 sf(s)/Unit Total: 26.0000 sf(s)
0.250" PLEXIGLAS G CLEAR CAST ACRYLIC SH

M 107871 x2

1) Batch # M110877 x3

2.0 HAND FINISH TH HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

Set up Machine as per folio FTA 018 and D3676 program

Dr. 09/01/20.

3.0 HAND FINISH TH HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks to 30" by 48"

Dr. 09/01/20.

4.0 THERMOFORMING THERMOFORMING MACHINE



Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3676 and Folio FTA 018

Dwg. Rev. B PRELIMINARY.

Folio Rev. B.

Dr. 09/01/21

(X5) - PTO

Process Sheet

Order: CU-DAR001 Dart Helicopters Services

Drawing Name: BUBBLE DOOR 412 VERTICLE REFERENCE

Job Number: 41414

Part Number: D36761

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1) Check Surface finish for undesired marks, voids, dimples etc.

2) Check depth of bubble to ensure conformity to drawing tolerances.

x3

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

ENGINEERING APPROVAL
09-01-23 ③

09/01/21

7.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim off excess flange material

2) Buff out any light scratches or blemishes

3) Etch part number and batch number

09/01/23

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09-01-23 ③

ENGINEERING APPROVAL
09-01-23 ③

09/01/23

1) Visually inspect for clarity, and proper formation.

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

transfer not entry

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Completion



POSITIVE RECALL

EFFECTIVE 09-01-15 AUTH 4

RELEASED DATE

W09-01-26